



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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D3393-1

Job Sheet 181694



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.ca
www.dartaerospace.com

Part No: D3393-1

Job Qty: 2 ea

DAS

Part Name: Battery Lock Casing

10 eq

21

9-88



Part Weight: 0 lbs

Status: Scheduled

Job Created: 8/4/18

Job Tracking No:

Due Date: 8/24/18

Created By: Marie Lajeune

Type: SOLD

Description:

Note: DWG REV A IPP A 05.02.18 New issue KJ/JLM

Ship Via:

Container No: S108644

Part: D3393-1

Job No: 181694

Serial No/Batch: S108644

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/09/18

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	8/24/18	8/24/18	0.00	0.00	Start Up Machining-2		DSP 18-9-9
100	Bandsaw	2 pcs	8/24/18	8/24/18	0.00	0.00	Bandsaw1		DSP 18-9-9
110	CNC Vertical Machining	2 pcs	8/24/18	8/24/18	0.33	1.03	HAAS1-3		DSP 18-9-9
130	QC	2 pcs	8/24/18	8/24/18	0.00	0.00	QC8 Machining-2		DSP 18-9-9
140	HandFinish	2 pcs	8/24/18	8/24/18	0.00	0.06	HandFinish1		SA 18-09-11
150	Powdercoat	2 pcs	8/24/18	8/24/18	0.00	0.07	Powdercoat6		DAS
160	QC	2 pcs	8/24/18	8/24/18	0.00	0.00	QC3		SEP 18 2018 68
170	Packaging	2 pcs	8/24/18	8/24/18	0.00	0.00	Packaging3-1		9-89
180	QC21-SA	2 Ea	8/24/18	8/24/18	0.00	0.00	QC21		SEP 18 2018

Part Op 100 - Cut blank: 1.500" x 1.500" x 3.125" long

Descriptions: 110 - Machine D3393-1 as per Folio FA510 and Dwg D3393 Identify as D3393-1

150 - START TIME: 5:30 O.T. 3:00 FINISH: 11:00

SEP 18 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X1.500	6061-T6 Bar 1.50 X 1.50	.5416 ft (.2708 ea)	90-Start up Operation	S033413

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.500X1.500	1	12	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Battery Lock Casing	0.750Inches ± 0.010	0.760 0.740	0.750	Diameter
2	Battery Lock Casing	0.625Inches ± 0.010	0.635 0.615	0.625	
3	Battery Lock Casing	1.250Inches ± 0.010	1.260 1.240	1.246	Diameter
4	Battery Lock Casing	1.088Inches ± 0.010	1.098 1.078	1.085	
5	Battery Lock Casing	0.734Inches ± 0.010	0.744	0.743	Diameter

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

			0.724	
6	Battery Lock Casing	2.658Inches ± 0.010	2.668 2.648	2.654
7	Battery Lock Casing	1.550Inches ± 0.010	1.560 1.540	1.549
8	Battery Lock Casing	0.125Inches ± 0.010	0.135 0.115	0.133
9	Battery Lock Casing	45.000Degrees ± 5.000	50.000 40.000	45° Angle
10	Battery Lock Casing	1.500Inches ± 0.030	1.530 1.470	1.490
11	Battery Lock Casing	0.750Inches ± 0.010	0.760 0.740	0.750
12	Battery Lock Casing	1.050Inches ± 0.010	1.060 1.040	1.055 Diameter
13	Battery Lock Casing	1.000Inches ± 0.010	1.010 0.990	0.999 Diameter
14	Battery Lock Casing	0.338Inches ± 0.010	0.348 0.328	0.337
15	Battery Lock Casing	0.563Inches ± 0.010	0.573 0.553	0.560
16	Battery Lock Casing	0.100Inches $+ 0.000$ $- 0.010$	0.100 0.090	0.098
17	Battery Lock Casing	3.000Inches ± 0.030	3.030 2.970	3.005
18	Battery Lock Casing	1.500Inches ± 0.010	1.510 1.490	1.490
19	Battery Lock Casing	0.375Inches ± 0.010	0.385 0.365	0.373
20	Battery Lock Casing	1.250Inches ± 0.030	1.280 1.220	1.246
21	Battery Lock Casing	0.125Inches ± 0.010	0.135 0.115	0.125
22	Battery Lock Casing	30.000Degrees ± 0.500	30.500 29.500	30° Angle

DIP 18-9-9

Plex 8/7/18 7:32 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					